

Date: Thursday, 28/05/2009 9:11:30 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HANDLE WELDMENT
Job Number :	48231		
Estimate Number :	10333		
P.O. Number :		Part Number :	D2530 BK
This Issue :	28/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2530 REV B
First Issue :	11	Project Number :	N/A
Previous Run :	46579	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :	JLD 09-05-28	Due Date :	12/06/2009
Comment :	Est Rev:E Removed Purchasing 05-11-07 JLM	Qty:	10 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W
		(10X)
Comment: Qty.: 3.0602 f(s)/Unit Total : 30.6023 f(s) Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049) Batch: M 111619 M-L 09/06/02		
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		(10X)
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Cut to length as per Dwg D2536 2-Deburr M-L 09/06/02		
3.0	QC5	INSPECT WORK TO CURRENT STEP
		(10X)
Comment: INSPECT WORK TO CURRENT STEP S 09/06/02 (4/0)		
4.0	D2534	Lock Plate
Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s) Pick: QTY Part # Description Batch 2 D2534 Lock Plate M 117176 2005 SP 09.06.08		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301 (10X) SP 09.06.08		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 28/05/2009 9:11:30 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 48231

Part Number: D2530

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Debur

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09-06-09

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-06-09 (410)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

10:00am

OVEN TEMPERATURE:

320°F

FINISH TIME:

10:30am

09-06-17 (410)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-06-17 (10)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 506

09-06-17 (10)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09-06-18

Job Completion



09-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

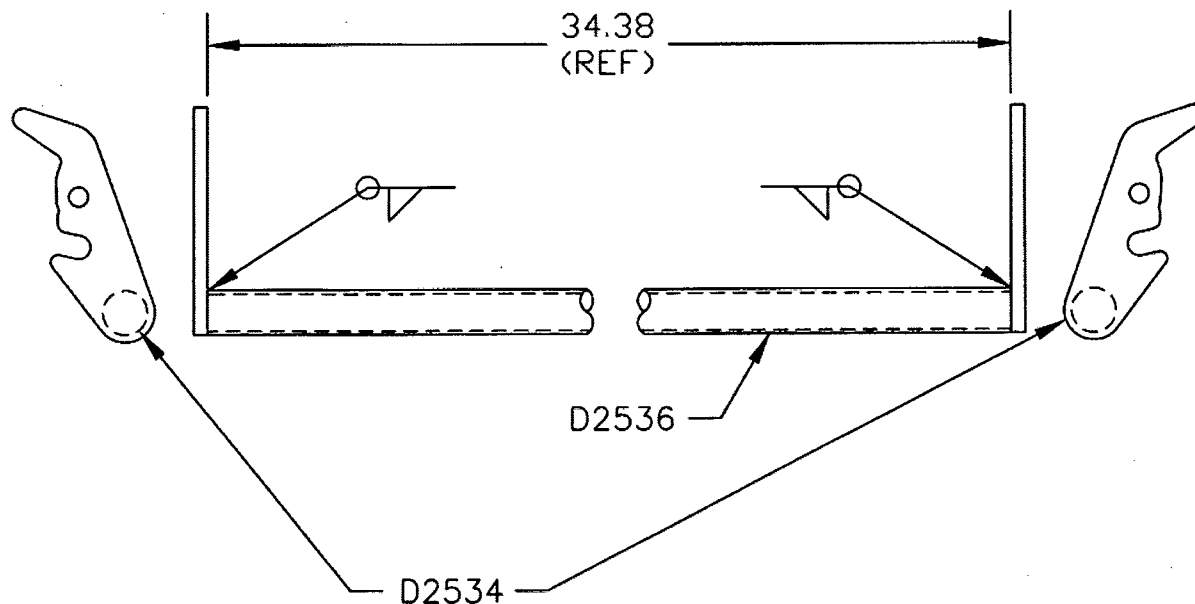


DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO.	REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	D2530	SHEET 1 OF 1
DATE		TITLE	
04.12.14		HANDLE WELDMENT	
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED
04.12.16 *[Signature]*

PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE



D2530 HANDLE WELDMENT

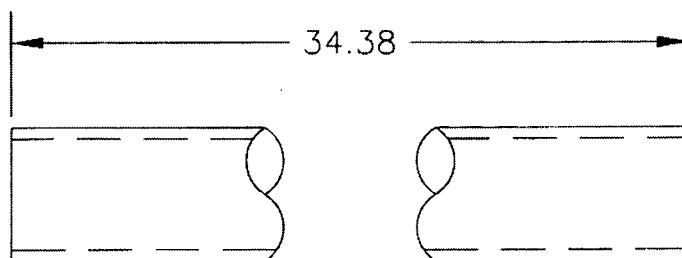
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 48231



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO.	REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	D2536	SHEET 1 OF 1
DATE	TITLE		SCALE
04.12.14	HANDLE		NTS
A	96.05.15	NEW ISSUE	
B	04.12.14	UPDATE NOTES	

04.12.14 *[Signature]*



REFERENCE ONLY

48231

D2536 HANDLE

- 1) MATERIAL: AISI 304/316 SS $\phi 0.75 \times 0.049$ WALL (REF. DART SPEC. M304TR0.750W.049)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED